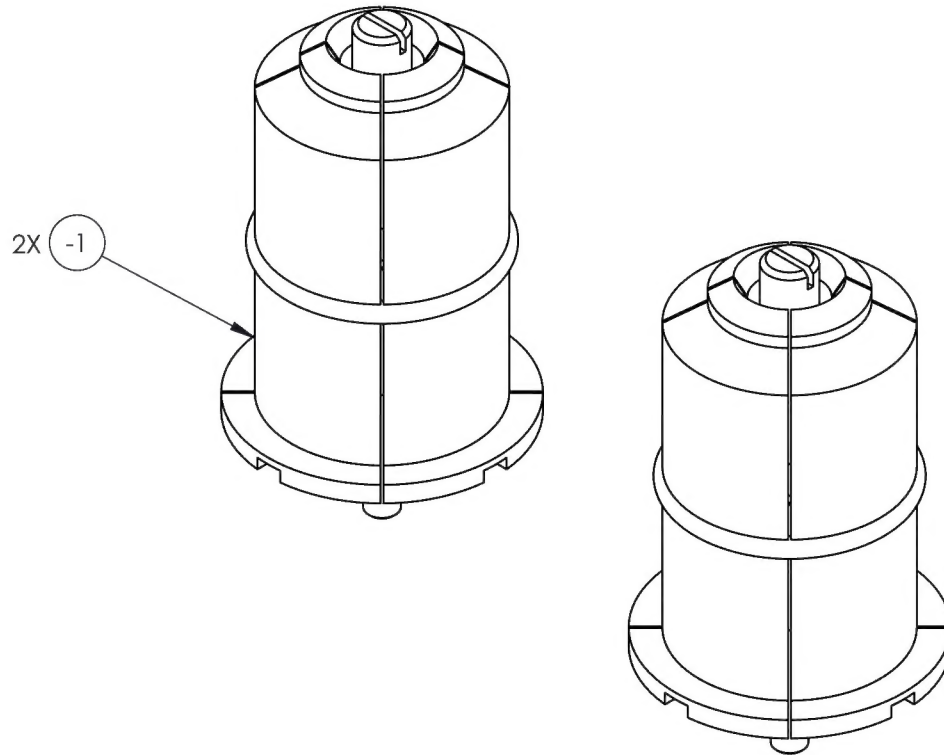


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/28/2017	DPD	JAG



- NOTES:  
 1. REF. EUROCOPTER T/N: 105-31821W5.  
 2. USED WITH RBE105-40001W1.

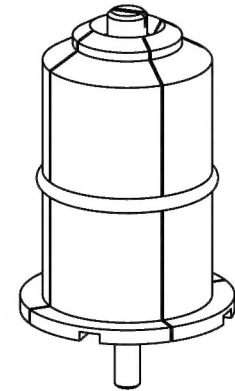
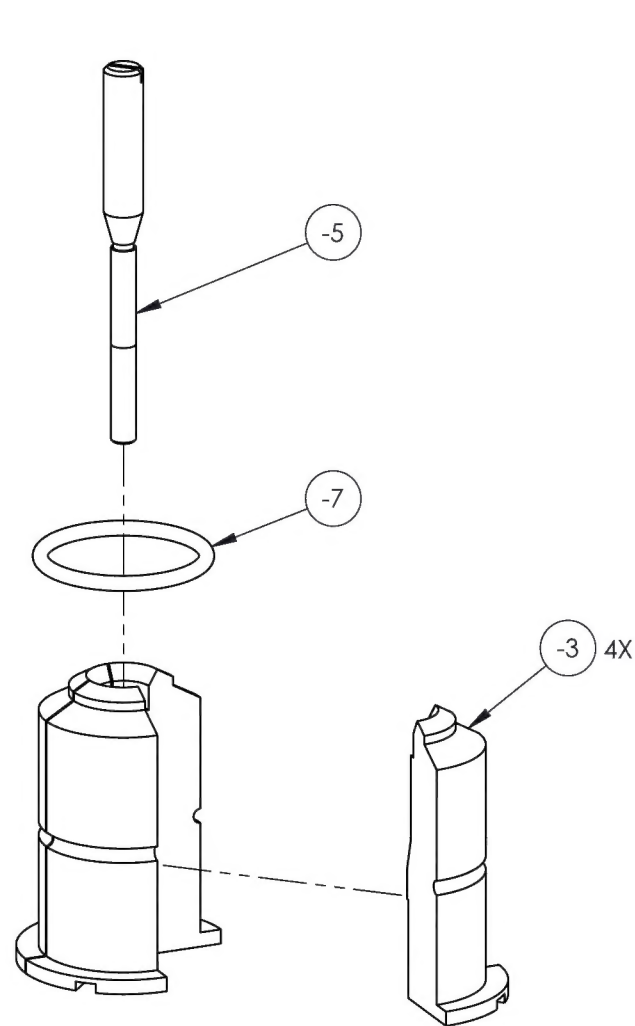
<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-31821W5</b>	REV <b>1</b>

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 1/20/2016
	SHEET 1 OF 4

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL ASSEMBLY			2
	4		-3		STAKING INSERT	4140/4142		3
	1		-5		POSITIONING SCREW	4140/4142		4
	1	B/O	-7		O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMMASTER-CARR #1174N608)	2
		B/O	-9	1	PISTOL CASE	PLASTIC	RSR GROUP #10137	N/S
	ASSY -1							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

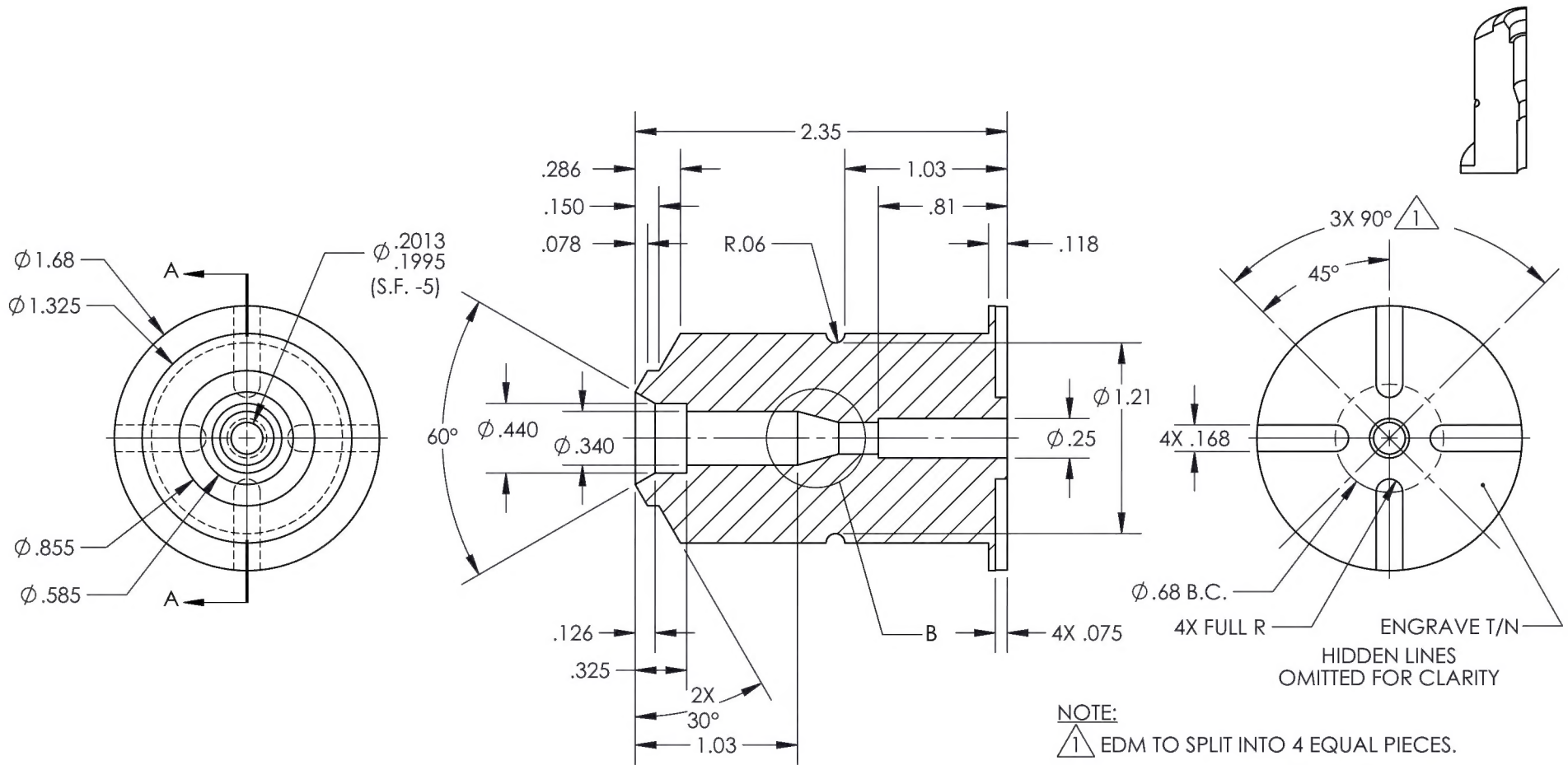


(1)  
STAKING TOOL ASSEMBLY

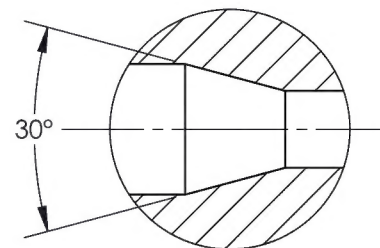
<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-31821W5-1</b>	REV <b>1</b>
MAT'L _____ TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>DUERFELDT</b>	USED ON MODEL
CHECKED: <b>CLOUGH</b>	<b>EC145</b>
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	
SCALE <b>2:3</b>	DATE <b>1/20/2016</b>
SHEET 2 OF 4	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SECTION A-A



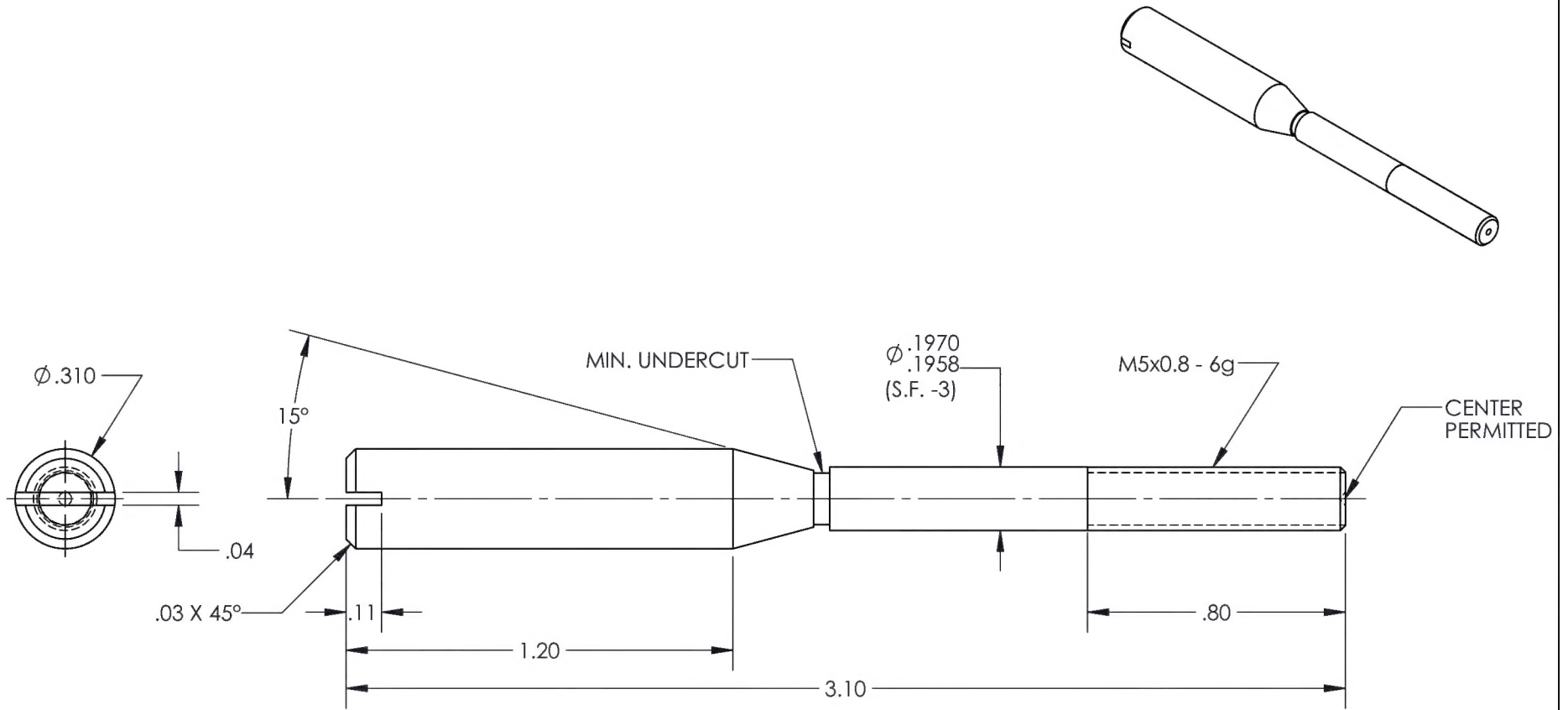
DETAIL B  
SCALE 2 : 1

③  
STAKING INSERT

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-31821W5-3</b>	REV <b>1</b>
MAT'L 4140/4142 HEAT TREAT RC 50-55 FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EC145
APPROVED: GILBERT	
SCALE 1:1	DATE 1/20/2016
SHEET 3 OF 4	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-5)

POSITIONING SCREW

<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-31821W5-5</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 1/20/2016	USED ON MODEL
	EC145
	SHEET 4 OF 4